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D350-591-213
Job Sheet 195594



Part No: D350-591-213

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Short Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 16671

Note: DWG REV H IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C 06-06-19 Added D2732-030 AS PER
DSI9294 JLMIPP REV:D 14.12.17 ADD DSI9712-011 DD VERF:JLM IPP Rev:C 06-06-27 Revised as per
DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM IPP Rev:E
10.11.15 update qty on AN4-11A DD ver:EC IPP REV:F 16.03.16 IIN REV:H DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
270	Packaging 1 - Pick Kit	10 pcs	8/9/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23	pc	AUG 13 2019
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		



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Container No: S205345



Part: D350-591-213

Job No: 195594

Serial No/Batch: S205345

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 19

					Packaging 1 - 30	
					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
280 QC 4	10 pcs	8/9/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
290 Packaging 3-1 - Stock - B4B	10 pcs	8/9/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
295 DC - 1 - B4B	10 pcs	8/9/19	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
300 QC 21 - FG	10 pcs	8/9/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

DAS
75
9-89

Max B

8/20/2019

Max B

8/20/2019

DAS
21
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21
AUG 20 2019

Part Op 280 - (QC4- 100% Inspect kits for completeness)
 Descriptions: 290 - Identify and pack for shipping as per PPP D350-591-213

295 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-213 CHG005
 300 - (QC21- Final Inspection - Work Order Release)

011341

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	20 Ea (2 ea)	270-Packaging 1 - Pick Kit	5158557
AN4-15A	Bolt	40 Ea (4 ea)	270-Packaging 1 - Pick Kit	5134436
AN5-36A	Bolt	20 Ea (2 ea)	270-Packaging 1 - Pick Kit	5193839
D2230-3	Mounting Lug	20 pcs (2 ea)	270-Packaging 1 - Pick Kit	5187436
D2618	Bushing	20 pcs (2 ea)	270-Packaging 1 - Pick Kit	5203210
D2732-030	Rubber Cushion - 3"	40 pcs (4 ea)	270-Packaging 1 - Pick Kit	5194369
D3078-041	Step Assembly, Hi Short LH	10 pcs (1 ea)	270-Packaging 1 - Pick Kit	5197998 / 5197998
D3235-1	Mounting Lug	20 pcs (2 ea)	270-Packaging 1 - Pick Kit	5187397
D3338-1	Mounting Lug	10 pcs (1 ea)	270-Packaging 1 - Pick Kit	5137808
MS21042L3	Nut	20 Ea (2 ea)	270-Packaging 1 - Pick Kit	5204283
MS21042L4	Nut	60 Ea (6 ea)	270-Packaging 1 - Pick Kit	5207668
MS21042L5	Nut	20 Ea (2 ea)	270-Packaging 1 - Pick Kit	5180182
NAS1149D0363J	Washer	40 Ea (4 ea)	270-Packaging 1 - Pick Kit	5191331
NAS1149D0463J	Washer	120 Ea (12 ea)	270-Packaging 1 - Pick Kit	5200189
NAS1149D0563J	Washer	40 Ea (4 ea)	270-Packaging 1 - Pick Kit	5134697
AN4-16A	Bolt	40 Ea (4 ea)	270-Packaging 1 - Pick Kit	5193853

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
270-Packaging 1 - Pick Kit	AN3-35A	20	458	0
	AN4-15A	40	272	0
	AN4-16A	40	545	0
	AN5-36A	20	147	0
	D2230-3	20	214	0
	D2618	20	247	0
	D2732-030	40	43	0
	D3078-041	10	4	0
	D3235-1	20	116	0
	D3338-1	10	86	0
	MS21042L3	20	2,194	0
	MS21042L4	60	2,342	0
	MS21042L5	20	781	0
	NAS1149D0363J	40	1,582	0
	NAS1149D0463J	120	3,545	0
	NAS1149D0563J	40	2,970	0

Part Specifications

Specifications could not be found.

Plex 5/27/19 12:48 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Change Record

PAGE 1 OF 1

Part Number: D350-591-213/-213GB/-214/-214GB

Description: HELI-ACCESS STEP, HIGH SKID, SHORT STEP, LH/RH

[illegible]

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Heli-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Heli-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Heli-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Heli-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Heli-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Heli-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.